

Date: Tuesday, 7/24/2007 10:51:30 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COVER
Job Number : 33723	
Estimate Number : 12962	
P.O. Number :	Part Number : D36413
This Issue : 7/24/2007 S.O. No. :	Drawing Number : D3641 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0005
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run :	Material :
Written By : <i>[Signature]</i> 07-07-24	Due Date : 7/31/2007 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC

Additional Product

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 0.8244 sf(s)/Unit Total : 1.6487 sf(s)
 M6061-T6 .032" THK sheet *M 16954*
 Batch: *IB 07-07-30*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3641
 Dwg Rev: *PROTO*
 Prog Rev: *TYPE*

IB 07-07-30

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*IB 07-07-30*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

IB 07-08-02

5.0 BRAKE NC NC BRAKE

*PTO*

Comment: NC BRAKE
 Form as per Dwg D3641-1

IB 07-08-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.08.08	S-0	one part bent as D3641-4	LE 07.08.08	Acceptable for prototype.	LE 07.08.08		LE 07.08.08	

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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6.0

QC5

ENGINEERING APPROVAL
INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D. J. 8/15

Job Completion



FOR ENGINEERING USE ONLY
AND FOR INSPECTION USE ONLY

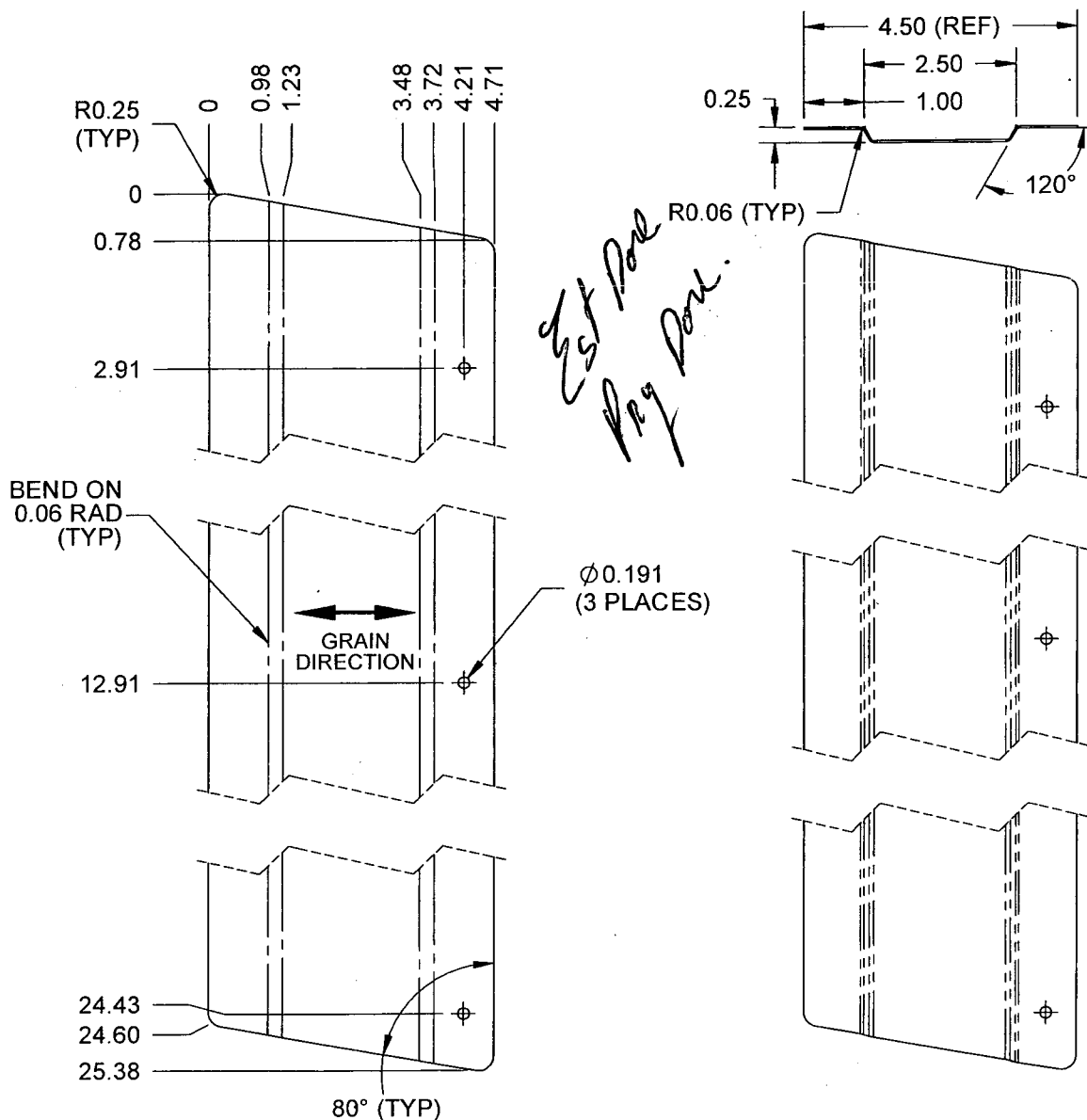
w/o corey

U.S. 08-15

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

LE 07.07.17

DESIGN TS	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED	DRAWING NO. D3641	REV. A SHEET 2 OF 2
DATE 07.06.26	TITLE COVER		SCALE 1:3



D3641-3F FLAT PATTERN

D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
(REPLACES GENEVA P/N G10606-4)

NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.032 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3641-3SM-FLAT-PATTERN/-4" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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